

Work Order ID 147089

Tuesday, May 31, 2016 10:59:44 AM

147089

Page 1

Item ID: D5321-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Ring

Stop ***NS2***

Start Date: 6/3/2016 Start Qty: 6.00

R

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 6.00

R

Customer:

Reference:

Approvals:

Process Plan: ML5Date: **MAY 31 2016**

Tooling:

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D5321

B

100

0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 32546
Possible supplier: ANCRA
Supplier P/N: 48557-11

C of C is required.

40JUN 01 2016DAS
13
9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

40x SP/16-7-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : _____																	

Work Order ID 147089

Tuesday, May 31, 2016 10:59:44 AM

147089

Page 2

Item ID: D5321-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Ring

Start Date: 6/3/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

DAS

38

9-89

JUL 20 2016

130

Identify as per dwg & Stock Location: 3164

0.00

130

Packaging

Memo

0.00

Packaging

DAS

5

9-89

JUL 21 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

DAS

21

9-89

JUL 22 2016

DAS

21

9-89

JUL 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY																																																												
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																								OTHER :																																							

Picklist Print

Tuesday, May 31, 2016 10:59:48 AM

Work Order ID: 147089

147089

Parent Item: D5321-3

D5321-3

Parent Item Name: Ring

Start Date: 6/3/2016

Required Date: 6/17/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 15.10.13 NEW ISSUE DD VERF:JLM IPP
REV:B 16.03.28 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
48557-11		Purchased			No		Each	0.0000		8 40			
48557-11									**				
Ring													

40X 8/16-7-18

DQA: _____ Date: _____



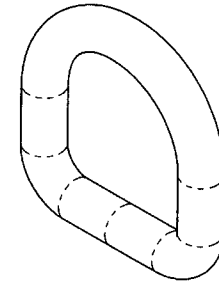
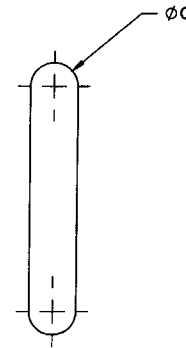
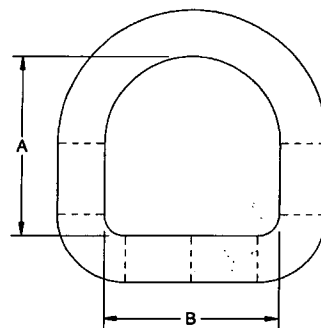
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SPECIFICATION CONTROL DRAWING



D5321-X RING

PART NUMBER	VENDOR	VENDOR P/N	BREAK STRENGTH	WORKING LOAD LIMIT	WEIGHT	DIM 'A'	DIM 'B'	DIM 'C'	MATERIAL
D5321-1	U.S.C.C.	MR15	6,000 lbs	2,000 lbs	0.22 lbs	1.50	1.45	0.39	ZINC PLATED STEEL
D5321-3	ANCRA	48557-11	5,000 lbs	1,666 lbs	0.09 lbs	1.50	1.50	0.25	CAD PLATED STEEL
D5321-5	MCMaster-CARR	9372T21	600 lbs	200 lbs	0.05 lbs	0.81	1.06	0.22	NICKEL PLATED STEEL

△

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: SEE TABLE

SHOP COPY
RETURN TO:
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 147-089-465
16-05-31

B	ADD D5321-5	DB	16.02.08
A	NEW RELEASE	DB	15.09.30
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	DD	D5321	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	RING	NTS
DATE	16.02.08	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2016-03-23
EN 16-548

APPROVED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32566

Purchase Order Date 6/1/2016 11:41:30 AM
PO Print Date 6/3/2016

Page Number 1 of 2

Order From :

ANCRA INTERNATIONAL, LLC
25591 NETWORK PLACE
CHICAGO, IL 60673-1255
US

VU-ANC001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

REVISED

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via:

FedEx Economy collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments			Promise Date				
Delivery Comments							
48557-11		Ring	6/7/2016	FN	40.00	\$6.95	\$278.00
			Yes		Each		
			6/7/2016				
AS PER DWG D5321 REV. B B147089							
8p/6-7-18						Line Total:	\$278.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	6/7/2016		1.00	\$0.00	\$0.00
			No				
			6/7/2016				
Procurement Quality Clauses							
A005 RIGHT OF ENTRY							
A016 PERSONNEL QUALIFICATION							
A026 CERTIFICATION OF MATERIAL CONFORMANCE							
A040 NOTIFICATION OF QUALITY ESCAPE							
A042 DART NOTIFICATION BY SUPPLIER							
A043 RETENTION OF QUALITY DOCUMENTS							

Line Total: \$0.00

Note:

6/3/2016



ANCRA
INTERNATIONAL LLC

875 West 8th Street
Azusa, California 91702

Phone: (310) 973-5000 • FAX: (310) 973-1138

Shipping List Number 803744-1

Customer
Order

P032566

Order
Date

06-03-16

Page

1

Ship To: 100312
DART AEROSPACE LTD
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Bill To: 100312
DART AEROSPACE LTD
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Contact : CHANTAL LAVOIE

Ship from: W ANCRA WEST AZUSA

Freight Terms :

Item Number	Description	Sell UM	Sell Qty	To Ship	Stk UM	Bin Loc	Stock Qty To Ship	Shipped Qty/UM
1 48557-11	Facility W :D-RING- 1 1/2"	EA	40		EA	R-28	4	4
	Cust PN: 71900-90							
	Rev. Level: G							
	Allocated: 07-15-16							
	Printed: 07-15-16 10:50:39							
CERTIFICATE OF CONFORMANCE								
WE HEREBY CERTIFY THAT THE ABOVE STATED PART NUMBERS REPRESENTED ARE NEW AND HAVE BEEN MANUFACTURED AND INSPECTED IN ACCORDANCE WITH OUR QUALITY ASSURANCE MANUAL, ALL RELEVANT DRAWINGS, SPECIFICATIONS, PURCHASE ORDER REQUIREMENTS, AND LEGIBLY MARKED IN ACCORDANCE WITH FAR 45.15, IF APPLICABLE.								
ALL CHEMICAL, PHYSICAL OR FUNCTIONAL TEST REPORTS RELEVANT TO THE CERTIFICATION OF CONFORMANCE ARE ON FILE IN OUR QUALITY ASSURANCE OFFICE.								
INSPECTOR						DATE 7/15/16		
Shortage Claim Policy								
Ancra customer is responsible for inspecting incoming shipments. Ancra must be notified within fifteen(15) days of receipt of shipment if material is not as ordered, quantity is either surplus or short, or if any damage has occurred in shipment. No claims submitted to Ancra will be accepted after fifteen(15) days of receipt.								

Pay
Terms

NET 30